

Amendments to the Description:

Please delete the previous abstract at page 20 and add the following new abstract:

A method and apparatus used to produce control data for building up a product layer by layer using freeform sintering and/or melting with a high energy beam. The correspondingly controlled apparatus for production of the products is further disclosed. The high energy beam is applied under the guidance of the control data set. Before beginning the freeform sintering and/or freeform melting, a compensation data set and/or a compensation function to compensate for manufacturing related effects caused by the sintering and/or melting is determined. The control data set is based upon a product target geometry data set and the compensation data set and/or the compensation function.